

Fire Red

Dart Aerospace Ltd.

22/12/2008 3:05:53 PM

auteux

Process Sheet

CU-DAR001 Dart Helicopters Services	Drawing Name	: HANDLE ASSEMBLY
44243		
Part Number	: D3331041	
10439	Drawing Number	: D3331 REV. C
	Project Number	: N/A
This Issue	: 22/12/2008	S.O. No. :
Prsht Rev.	: NC	
First Issue	: / /	Type : LARGE FAB ASSY
Previous Run	: 37082	
Written By	:	Due Date
Checked & Approved By	: <u>JLD 08.10.23</u>	: 20/01/2009
Comment	: Est: C 05.05.26 Added D3158-050 KJ/JLM	Qty: 4 Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M1025TR0875W125	1025 Round tubing .875 x .125w
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Comment: Qty.: 1.5000 f(s)/Unit Total: 6.0000 f(s)

1025 Round Steel Bar

Material: AISI 1010-1025 Ø0.875" tubing, 0.125" wall

(M1025TR0.875W.125)

Batch: M18029

EL 9-1-23 18

2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

1- Cut handle to finish length as per Dwg D3331

2- Form as per Dwg D3331 using DT8760 crimping Jig

EL 9-1-23

3.0	LATHE CONV.	CONVENTIONAL LATHE
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Comment: CONVENTIONAL LATHE

Turn as per Dwg D3331

Identify as D3331-1

SL 09/01/26 (2)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SL 09/01/26 (2)

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

J.L 09/01/26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 22/12/2008 3:05:53 PM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HANDLE ASSEMBLY

Job Number: 44243

Part Number: D3331041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

238032

3/16" Dowel Pin 1" long



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
3/16" Dowel Pin 1" long

Pick:

Qty	Part Number	Description	Batch
1	238-032	3/16"-1" long Dowel	M106162

EL 9-2-18

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1- Deburr

2- Drill dowel hole as per Dwg D3331

3- Insert and Weld dowel as per Dwg D3331

Qty	Part Number	Description	Batch
A/R	N/A	Steel Rod	M108350

EL 9-2-18

8.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

09-02-18

(x2)

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3

START TIME: 4:00am

OVEN TEMPERATURE: 320°F

FINISH TIME: 9:30am

09-02-24

(x2)

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

BR 09-02-24

(2)

11.0

GP78R

Black Vinyl Grid



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Black Vinyl Grid

Pick:

Qty	Part Number	Description	Batch
1	GP-78R	Black Vinyl Grid	111076 2P

111076 2P

M107350

09/02/24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 22/12/2008 3:05:53 PM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HANDLE ASSEMBLY

Job Number: 44243

Part Number: D3331041

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

D3158

Heat Shrink Tubing



Comment: Qty.: 0.4166 f(s)/Unit Total : 1.6664 f(s)
Heat Shrink

Pick:

Qty Part Number
5" D3158

Description
Heat Shrink

Batch

2465

88 09/02/2009

13.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1
Assemble as per Dwg D3331
Identify as D3331-041

09.03.23

(X2)

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09/03/23 (X2)

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: 5443

09/13/23

16.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/03/24

Job Completion



mf 09-03-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

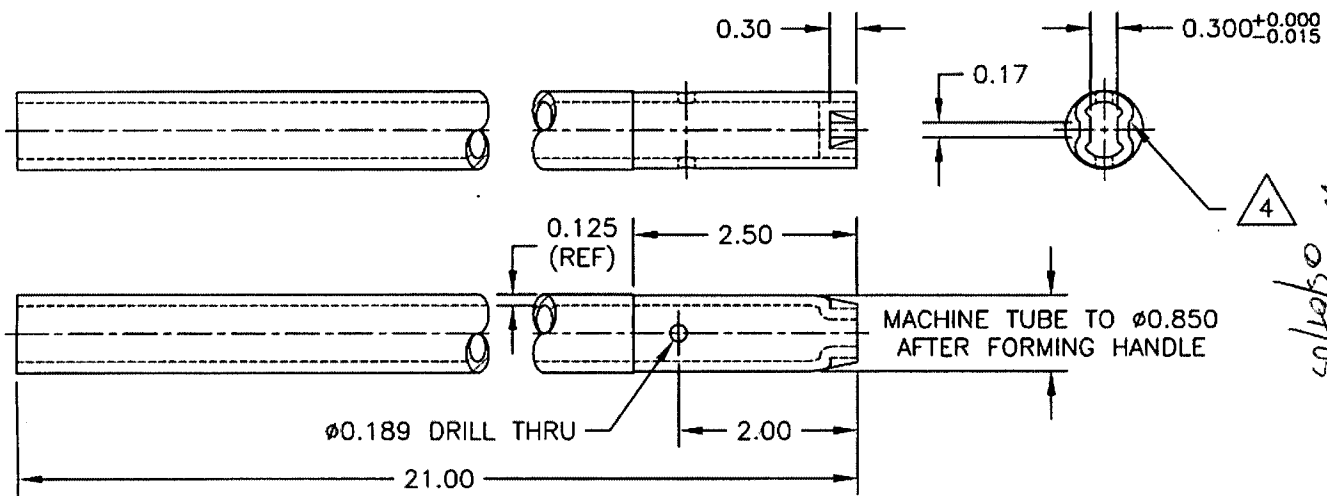
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

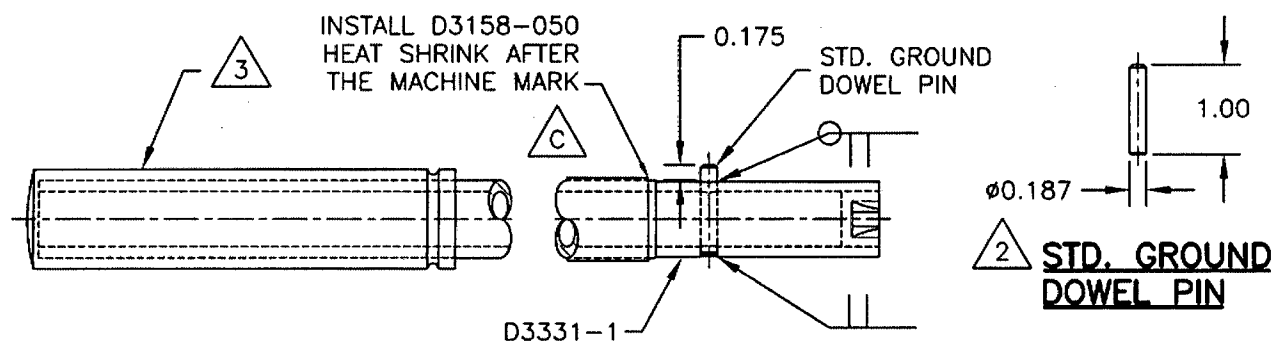
NOTE: Date & initial all entries

DART

RELEASED
04/07/05



D3331-1 HANDLE



D3331-041 HANDLE ASS'Y

NOTES:

- 1) MATERIAL: 1025 ROUND BAR STEEL PER MILL-S-7097 (REF. DART SPEC. M1025TR0.875W.125)
- 2) STD. GROUND DOWEL PIN, $\phi 3/16$ " x 1.00" LONG
POSSIBLE SUPPLIER: SPAENAU, P/N 238-032
- 3) STD. BLACK VINYL GRIP, 7/8" I.D. x 4 3/4" LONG
POSSIBLE SUPPLIER: REID TOOL SUPPLY CO., P/N GP-78R
- 4) FORM USING TOOLING DT8760
- 5) FINISH: POWDER COAT FIRE RED (REF. 4.3.5.10) PER QSI 005 4.3
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE IN INCHES
- 8) BREAK ALL SHARP EDGES 0.005 TO 0.010

UNCONTROLLED COPY
WITHOUT MARK
NO. 44243

DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA
DATE	TITLE	REV. C
05.05.20	HANDLE WELDMENT	SHEET 1 OF 1
A	04.11.29	SCALE
B	05.02.18	1:2
C	05.05.20	